

Date: Monday, 22/09/2008 10:13:33 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CONSOLE SIDE LH (206 HI-SLOPE)	
Job Number :	42144			
Estimate Number :	11000			
P.O. Number :		Part Number :	D26021	
This Issue :	22/09/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D2602 REV B	
First Issue :	22/09/2008	Project Number :	N/A	
Previous Run :	33906	Drawing Revision :	B	
		Material :		
Written By :		Due Date :	06/10/2008	Qty: 8 Um: Each
Checked & Approved By :	<u>JUL 08.9.22</u>			
Comment :	Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM Est Rev:F RevB as per dwg ECN1059 DD verified by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 1.4146 sf(s)/Unit Total : 11.3165 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>107461</u> <u>IB 8-9-22</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <u>IB 8-9-22</u> 2-Deburr if necessary <u>IB 8-9-22</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-9-22</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>08/09/22</u> <u>IB</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 10:13:34 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 42144

Part Number: D26021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary
2-Form as per Dwg D2602

SB

08/10/07

(8)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/07

(8)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/10/07

(8X)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-07

(X8)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 175

JS

08/10/07

(X8)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/07

Job Completion



U 08.10.08

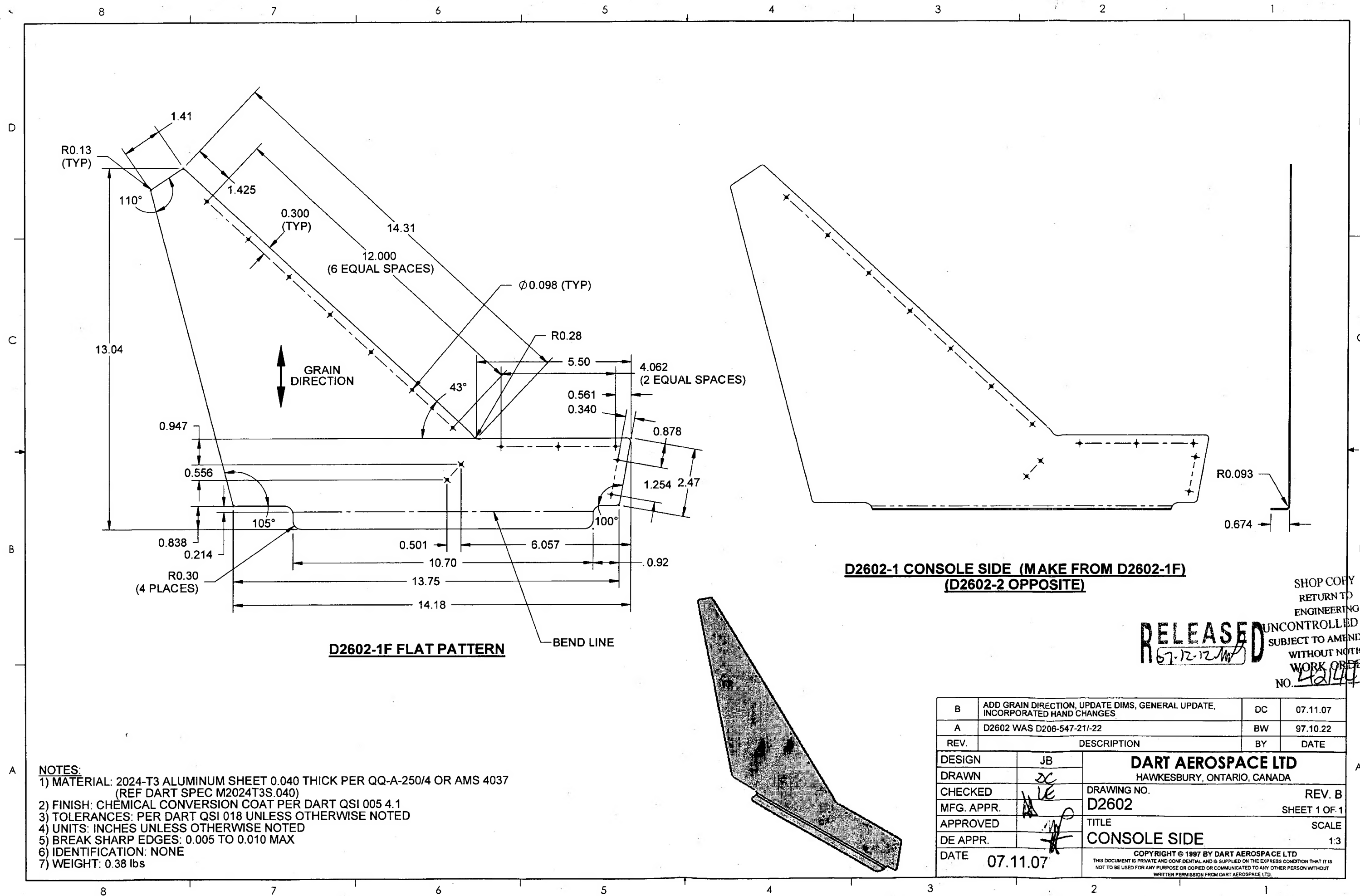
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2602-1F FLAT PATTERN

D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.38 lbs

RELEASED
67-12-12
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42141

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2602 WAS D206-547-21/-22	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	XC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IE	DRAWING NO.	REV. B
MFG. APPR.		D2602	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	